

Work Order ID 77823

December-21-11 3:41:19 PM

77823

Page 1

Item ID: D3256-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel
 Start Date: 21/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3256	D

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

304 035

Memo

1-Cut as per Dwg D3256

Dwg Rev: P

Prog Rev: B

2-Deburr if necessary

B12-1-4

④

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

B12-1-4

120 QC8- Inspect parts - second check 0.00

120

QC

Quality Control

Memo

Sizeloh

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 05/01/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/2/13 *[Signature]*
ME
12-02-13

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Picklist Print

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Page 1

Work Order ID: 77823

77823

Parent Item: D3256-1

D3256-1

Parent Item Name: Panel

Start Date: 21/12/2011

Required Date: 05/01/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

85.8600

0.987

8.311579

12.

M304S22GA

B12-1-4

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT020

85.86

109057

3.3

117379

7.06

118271

73

118400

2.5

118271

(9)

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Dart Aerospace Ltd

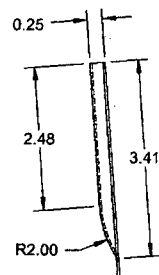
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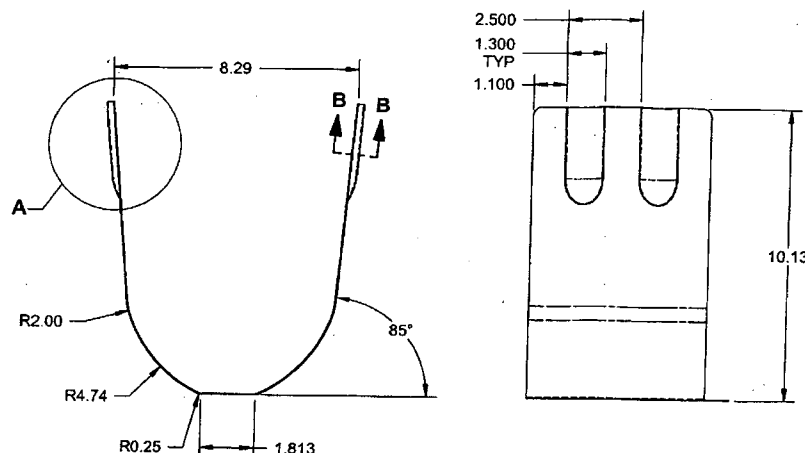
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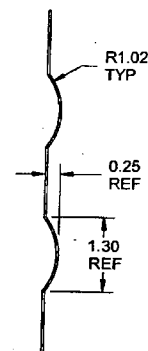
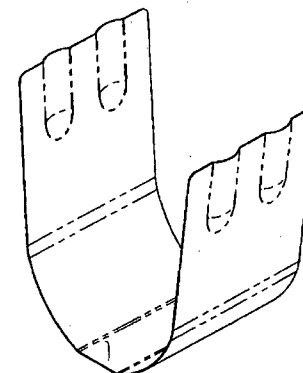
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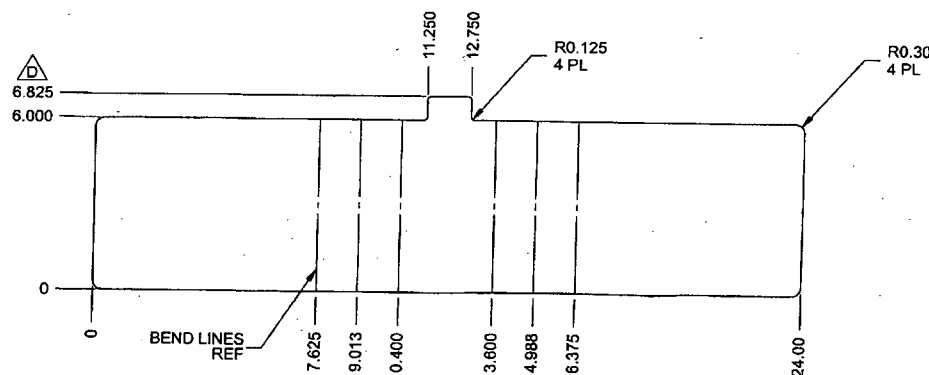
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN 1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO **77823** **MLW** **RELEASE**
2011-11-10
11/12/21

D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZIN B7-1); 0.83 WAS 0.45 (ZIN C8-2). REASON: PART11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. D
SHEET 1 OF 2
TITLE **ACCESS PANEL** SCALE NTS

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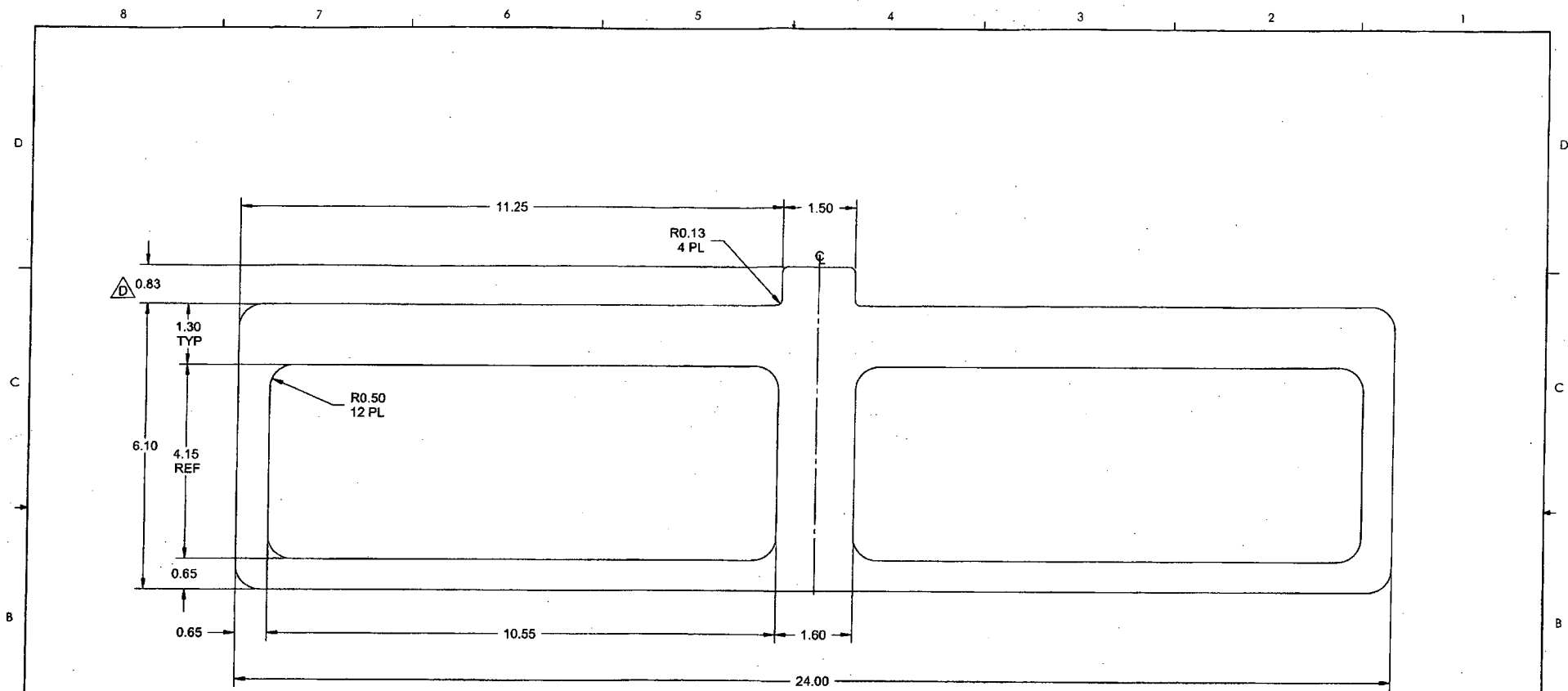
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77023



D3256-3 GASKET

RELEASE
R 2011-11-10
W

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
REF. DART SPEC. MDURAS.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	#	DART AEROSPACE LTD.	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3256	REV/D SHEET 2 OF 2
MFG. APPR.		TITLE ACCESS PANEL	SCALE N/A
APPROVED		DATE 11.10.25	
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD. ALL RIGHTS RESERVED.	
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